

Work Order ID 111316

January-10-14 2:37:33 PM

\*111316\*

*rec 8/14/14*  
**PRELIMINARY ISSUE**

Page 1

Item ID: D4652-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Air Valve, 1.16 Id Disk Type

Stop

\*NS2\*

Start Date: 1/10/14 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 1/10/14 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan: *u*

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	DAS 27 9-89							
D4652	<i>B 222</i>	<i>RON C</i>							

100

\*100\*

Purchasing

Purchasing

Memo

Issue P/O: *P022049*

Purchase Part Number: *AV364302*

Supplier: BIRK AEROSYSTEM CORPORATION

Note: d4652-3 is included in the -1  
Certificate of conformity is required

0.00

0.00

0.00

*u for Mike G 14-01-10*

110

\*110\*

Packaging

Packaging

Memo

Receive & Inspect for Damage & Mat'l Certs

*1/14/13 (12)*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input checked="" type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14/01/13	110	x 12.	<div>Part Found to have a Poor Finish.</div> <div>RC supplier issue</div>					
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier	x									
Training										
Transport										
Unapproved										

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 111316

**\*111316\***

Page 2

January-10-14 2:37:33 PM

Item ID: D4652-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Air Valve, 1.16 Id Disk Type  
 Start Date: 1/10/14 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 1/10/14 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

RECEIVED 4/21/10 AUTH                       
 RELEASED                      DATE 1/16/24

MF 14-1-14  
 Insp. as per Draw Release Rev Q 1/11/23  
 DAS 27 9-89

# Picklist Print

January-10-14 2:37:32 PM

Page 1

Work Order ID: 111316

Parent Item: D4652-1

Parent Item Name: Air Valve, 1.16 Id Disk Type

Start Date: 1/10/14

Required Date: 1/10/14

Start Qty: 12.00

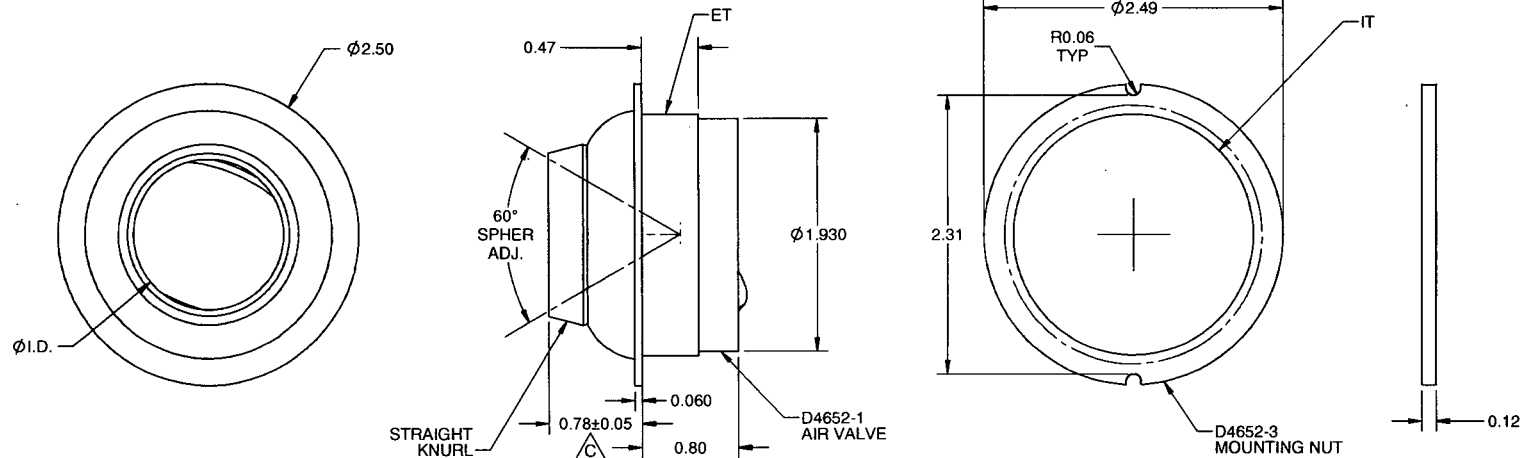
Required Qty: 12.00

Comments: lpp RevA 12.05.31 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>AV264301-2</del> Air Valve, 1.16 Id Disk Type		Purchased	No			110	Each	0.0000	1	12		1/4/01/13	(12)

AV364302-QCP820

# **SPECIFICATION CONTROL DRAWING**



## **D4652-X AIR VALVE/ MOUNTING NUT**

DART PART NUMBER	DESCRIPTION	VENDOR	VENDOR PART NUMBER	MATERIAL	FINISH	INSIDE DIAMETER "ID"	MOUNTING NUT TYPE	EXTERNAL THREAD "ET"	INTERNAL THREADS "IT"	WEIGHT (lbs)
D4652-1	AIR VALVE	BIRK AEROSPACE CORPORATION	AV364302	ALUMINUM	OCP820 SATIN BLACK	1.25	ALUMINUM	2.00-24 UNS-2A	N/A	0.08
D4652-3	MOUNTING NUT	BIRK AEROSPACE CORPORATION	MN8005-1	ALUMINUM	OCP820 SATIN BLACK	N/A	ALUMINUM	N/A	2.00-24 UNS-2B	0.02

### **NOTES:**

- 1) MATERIAL: PER TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: PER TABLE

C	REVISE VENDOR P/N AND SPECIFICATIONS & REMOVED NOTE 8) (ZN B4-1,B5-1, B6-1 & A8-1)	RF	13.11.08
B	ADD P/N TABLE/DESCRIPTION	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. PC2
MFG. APPR.		D4652	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		AIR VALVE	NTS
DATE	13.11.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO22049

Purchase Order Date 11/14/2013

PO Print Date 12/4/2013

Page Number 1 of 1

Order From :  
BIRK AEROSYSTEMS CORPORATION  
14321 COMMERCIAL DRIVE  
GARDEN GROVE, CALIFORNIA 92843

VU-BIR001

Ship To : DART AEROSPACE LTD  
823 MACTAVISH ROAD  
CALGARY, AB T2E 7G9  
CANADA

Contact Name  
Vendor Phone 714-554-9782  
  
Ship To Contact  
Ship To Phone  
  
Ship Via FedEx PI collect  
Ship Acct

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency USD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req. Qty/ Unit of Measure	PO Unit Price	Extended Price
1	AV364302-QCP820	Air Valve (Satin Black)	1/3/2014 No 1/3/2014		12.00 Each	\$488.92	\$5,867.04
***NOTE*** Price to be adjusted at a later date. *****							
Line Total:							\$5,867.04
2	AV364302-QCP820	Air Valve (Satin Black)	1/3/2014 No 1/3/2014		108.00 Each	\$0.00	\$0.00
***NOTE*** Pricing to be advised.							
Line Total:							\$0.00
PO Total:							\$5,867.04

PO Instructions: \*\*\*NOTE\*\*\*  
Attn:Harvey Siemens

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required - YES NO  
PST# 6122-5207

Change Nbr: 3 Change Date: 11/22/2013





**BAC****BIRK AEROSYSTEMS CORPORATION**

14321 Commerce Drive

Garden Grove, California 92843

Telephone: (714) 554-9782 Telefax: (714) 554-3659

DATE: 01/07/14

CUSTOMER PO: PO22049

SHIPPER NO.: DAR140107

**CERTIFICATE OF CONFORMITY / PACKING LIST**

SHIP TO: **DART AEROSPACE LTD**  
**823 Mactavish Road**  
**Calgary, AB T2E 7G9**  
**Canada**

PO ITEM	PRODUCT NO.	DESCRIPTION	QUANTITY		LOT CODE	LOT QTY	SERIAL NO.
			ORDERED	SHIPPED			
1	AV364302-QCP820	Air Valve (Rev. -)	12	12	1401162 MFG: 1402	12	-
		<b>VALUE FOR CUSTOMS:</b> <b>\$5867.04 USD</b> <b>Country of Manufacture:</b> <b>United States</b>					

CLAIMS FOR SHORTAGES OR MATERIAL DISCREPANCY MUST BE MADE WITHIN 15 DAYS AFTER DATE SHIPPED.

**CERTIFICATE OF CONFORMANCE:** THIS IS TO CERTIFY THAT THE PARTS FURNISHED ON THIS ORDER HAVE BEEN FUNCTIONALLY TESTED IN ACCORDANCE WITH STANDARD PROCEDURES DEFINED BY BAC. MATERIAL AND/OR PARTS FURNISHED IN THIS ORDER HAVE BEEN MANUFACTURED IN ACCORDANCE WITH ALL APPLICABLE INSTRUCTIONS AND SPECIFICATIONS. PHYSICAL AND CHEMICAL DATA WHICH PERTAINS TO THIS ORDER ARE AVAILABLE FOR INSPECTION.

QTY VERF

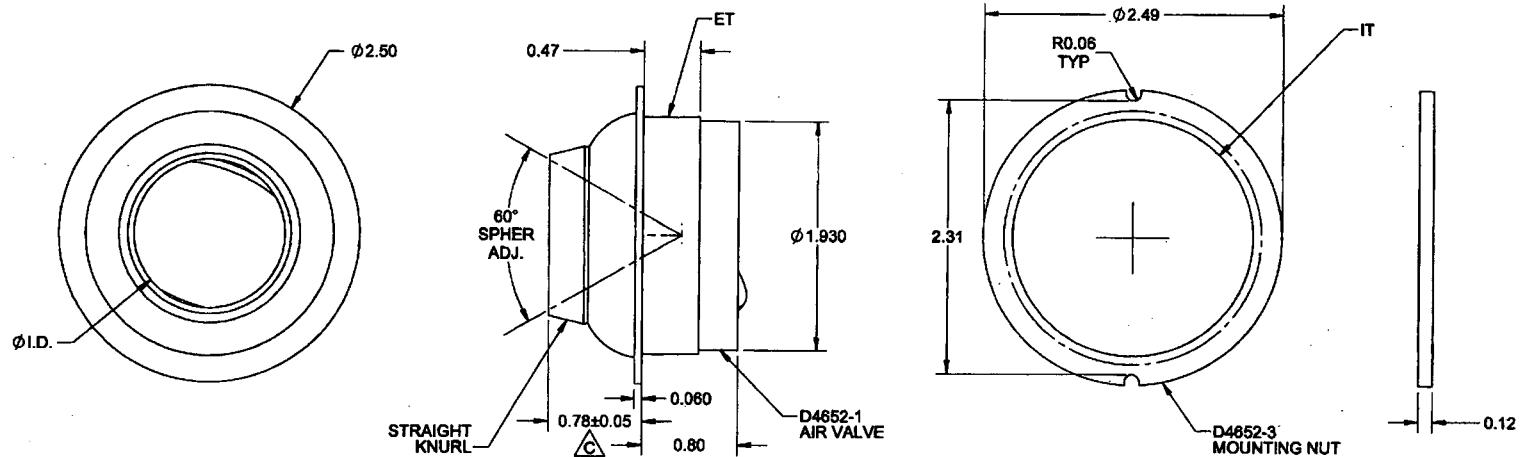
**FEDEX P1 COLLECT****3#**  
**QUALITY CONTROL INSPECTOR**

1

100



# **SPECIFICATION CONTROL DRAWING**



## **D4652-X AIR VALVE/ MOUNTING NUT**

DART PART NUMBER	DESCRIPTION	VENDOR	VENDOR PART NUMBER	MATERIAL	FINISH	INSIDE DIAMETER "ID"	MOUNTING NUT TYPE	EXTERNAL THREAD "ET"	INTERNAL THREADS "IT"	WEIGHT (lbs)
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D4652-3	MOUNTING NUT	BIRK AEROSPACE CORPORATION	MN8005-1	ALUMINUM	QCP820 SATIN BLACK	N/A	ALUMINUM	N/A	2.00-24 UNS-2B	0.02

### **NOTES:**

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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: PER TABLE
- 8) PURCHASE VENDOR ASSEMBLY P/N AV364302-QCP820. VENDOR ASSEMBLY INCLUDES AV364302 AND MN8005-1

C	REVISE VENDOR P/N AND SPECIFICATIONS (ZN B4-1, B5-1, B6-1 & A8-1)	RF	13.11.08
B	ADD P/N TABLE/DESCRIPTION	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	DL		
MFG. APPR.	MG		
APPROVED			
DE APPR.			
DATE	13.11.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4652** REV. C  
SHEET 1 OF 1  
TITLE **AIR VALVE** SCALE NTS

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